MITSUBISHI MOTOR SALES OF AMERICA, Inc.

TECHNICAL SERVICE BULLETIN

SUBJECT:

WINDSHIELD INSTALLATION

NO.	TSB-90-42B-001
DATE	January, 1990
MODEL	All Models

PURPOSE

This bulletin shows typical updated windshield and moulding installation service procedures along with new adhesive and primer recommendations. Use this bulletin along with the appropriate service manual when replacing windshields or bonded type windshield mouldings.

MATERIALS

	ADHESIVE	PRIMER
NEW	3M Super Fast Urethane Auto Glass Sealant Part No. 8609 or equivalent	3M Super Fast Urethane Primer Part No. 8608 or equivalent

CAUTION:

During the windshield repair/replacement process do not move the vehicle unless absolutely necessary. If the vehicle must be moved then move it **VERY SLOWLY**. While the adhesive is hardening the windshield can shift causing leaks or windshield damage.

Continued . . .

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FILE UNDER: Group 42B Body Repair in the Dealer Service Information Binder (729)

CIRCULATE TO:

- ☐ GENERAL MANAGER
- ☐ PARTS MANAGER
- ☑ TECHNICIAN
- ☐ SERVICE ADVISOR
- ☑ SERVICE MANAGER
- ☐ WARRANTY PROCESSOR
- ☐ SALES MANAGER

WINDSHIELD AND WINDOW GLASS INSTALLATION PROCEDURE

WINDOW GLASS WITH DAM INSTALLATION

1. Using isopropyl alcohol, remove dirt and grease from the glass and body surface to which the adhesive will be applied. After cleaning, allow the parts to dry for more than **THREE MINUTES**.

2. Remove the backing paper from the window dam, and attach the window dam to the glass (Figure 1).

***NOTE: FOR THE INSTALLATION POSITION OF THE WINDOW DAM REFER TO THE APPLICABLE SERVICE MANUAL.**

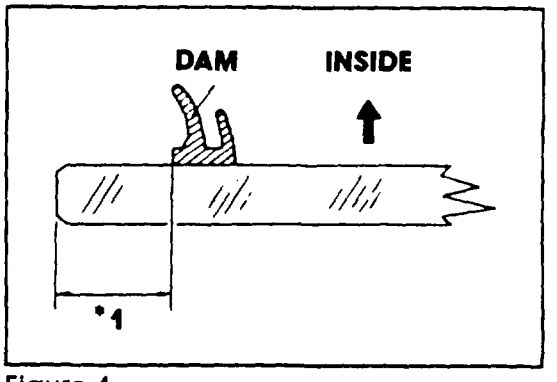

Figure 1

PRIMER APPLICATION

Apply 3M Super Fast Urethane Primer (#8608 or equivalent), to the entire bonding surface of the glass, both to the inside surface and onto the edge of the glass (Figure 2). Allow to dry for **FIVE** minutes.

NOTE: DO NOT TOUCH THE SURFACES THAT ARE COATED WITH PRIMER. IF THE SURFACES BECOME CONTAMINATED WITH ANY SUBSTANCE REAPPLY THE PRIMER.

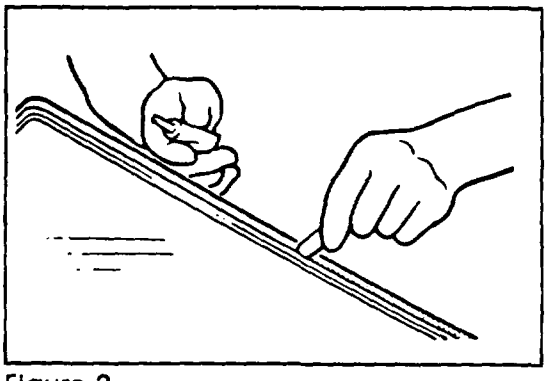
Figure 2

OLD ADHESIVE REMOVAL

Using a sharp knife, cut the old adhesive from the body pinch-weld flange down to a thickness of no greater than 2 mm (0.08 in.) figure 3.

NOTE: BE CAREFUL NOT TO REMOVE MORE ADHESIVE THAN NECESSARY, AND ALSO DO NOT DAMAGE THE PAINT ON THE BODY SURFACE. IF THE PAINT IS DAMAGED, REPAIR THE DAMAGED AREA WITH TOUCH-UP PAINT.

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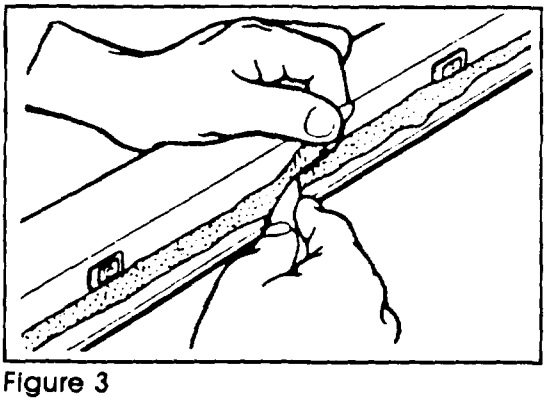
Figure 3

ADHESIVE APPLICATION

Using an adhesive application gun, apply 3M Super Fast Urethane Auto Glass Sealant (#8609 or equivalent) to the window glass mounting surface.

1. Cut the nozzle tip into a V shape.
2. For the correct size of the nozzle tip, the application amount, and adhesive placement, refer to the applicable Service Manual (Figure 4).

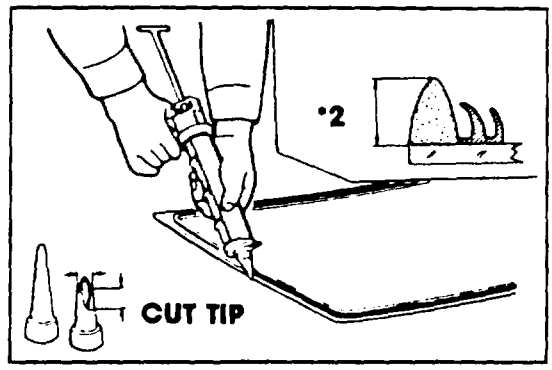

Figure 4

GLASS INSTALLATION

1. Using a glassholder, place the glass in the body opening.
2. Press the glass gently so that no adhesive is squeezed out from under the glass edge.

NOTE:

A. Do not move the glass and mouldings after installing them onto the body.
B. Place the glass in the original position.
C. Use care not to cover the water drainage groove with adhesive.

3. After bonding the glass to the body, apply 3M Super Fast Urethane Auto Glass Sealant (#8609 or equivalent) completely around the outside perimeter of the bonded area (Figure 5).

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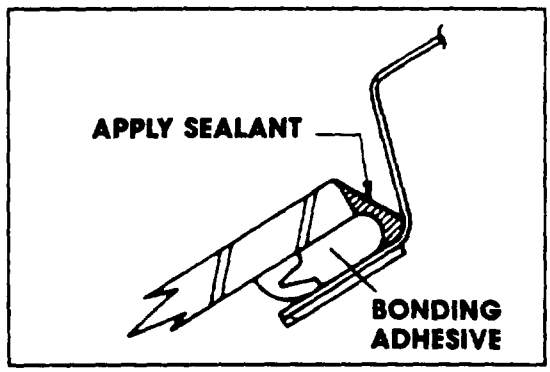

Figure 5

4. Perform a water test for the newly bonded glass. Use a gentle cold water spray, being careful not to direct a powerful stream of water on the new adhesive.
   Allow the water to flow over the edges of the glass. In the event there are leaks, carefully dry the leak area and apply sealant to the leak point (Figure 6).

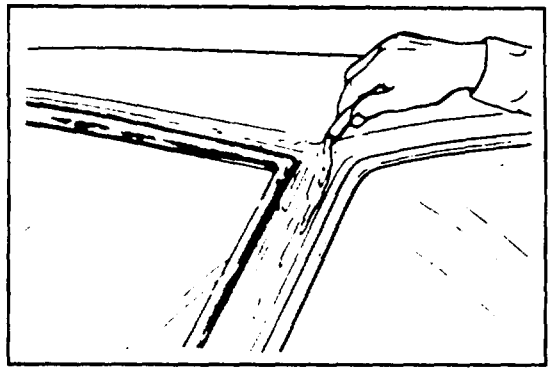

Figure 6

CAUTION

If it is necessary to move the vehicle, MOVE IT SLOWLY.

5. Using a clean lint free cloth liberally dampened with GLOW Chemical Solvent GS-35, 3M Part number (8984 or equivalent) wipe away dirt from the glass perimeter and the body. **DO NOT DAMAGE THE NEW ADHESIVE SEAL.**

WINDOW MOULDING WITH CLIP REPLACEMENT PROCEDURE

1. Cut the old adhesive using a tool similar to figure 7.

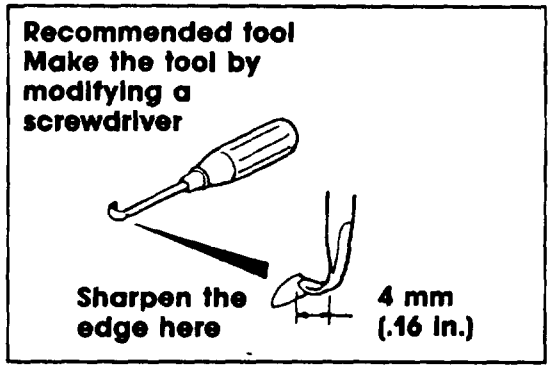

Figure 7

2. Scoop out the old adhesive at the clip installation point, then apply 3M Super Fast Urethane Auto Glass Sealant (#8609 or equivalent) to the clip installation point and install the molding (Figure 8).

NOTE:
For the clip positions, refer to the applicable Service Manual.
BE CAREFUL NOT TO DAMAGE THE GLASS OR THE BODY.

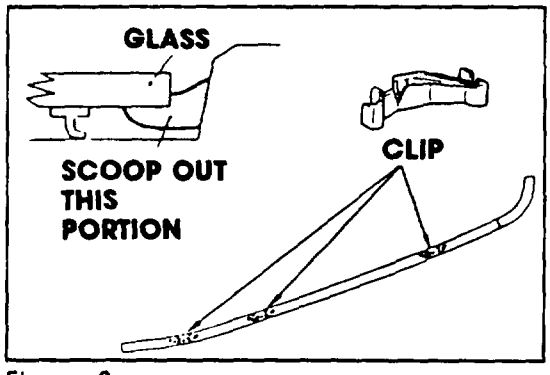

Figure 8

Continued . . .

BONDED TYPE WINDSHIELD MOULDING REPLACEMENT PROCEDURE

1. Use a screwdriver to carefully pry up the moulding end. Then by hand pull off the moulding from the windshield (Figure 9).

NOTE: If the moulding adheres too firmly to remove by hand, use a knife to remove the moulding.

2. Refer to Figure 7 for special tool make directions.

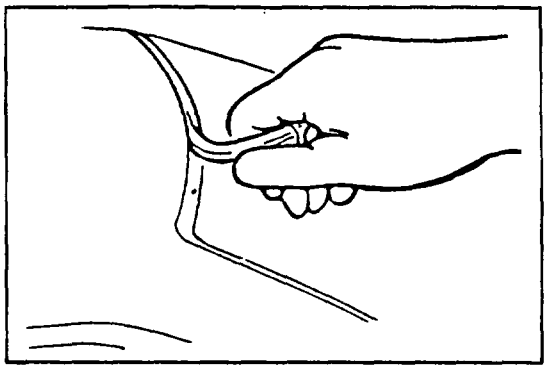

Figure 9

3. Using the special tool scrape off the old adhesive to a uniform thickness (Figure 10).

NOTE: Do not scrape off more adhesive than necessary for moulding installation. Do not damage the coated surfaces. If the painted surface is damaged, touch up with paint.

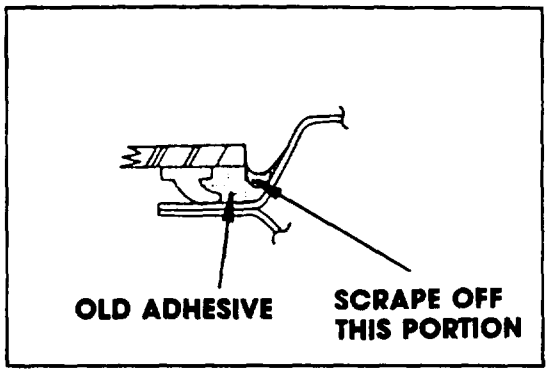

Figure 10

4. Cut off the lower portion of a new moulding (Figure 11).
5. Apply 3M Super Fast Urethane Primer (#8608 or equivalent) to the moulding.

DO NOT TOUCH THE SURFACES THAT ARE COATED WITH PRIMER.

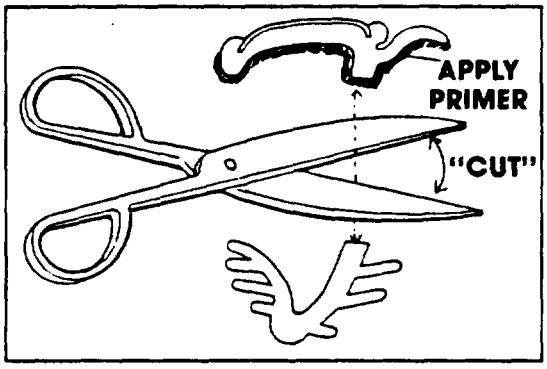

Figure 11

6. Apply 3M Super Fast Urethane Auto Glass Sealant (#8609 or equivalent) to the illustrated portion of the moulding and install the moulding before the adhesive hardens (Figure 12).
7. Using a spatula or equivalent, remove excess adhesive that has been forced out from under the newly installed moulding. Then use Glow Chemical Solvent (#GS-35 or 3M Part number 8984 or equivalent) to wipe off any remaining adhesive.
8. **UPON COMPLETION, DO NOT MOVE THE VEHICLE FOR 4 HOURS, AT ROOM TEMPERATURE, ALLOWING THE ADHESIVE TO HARDEN.**

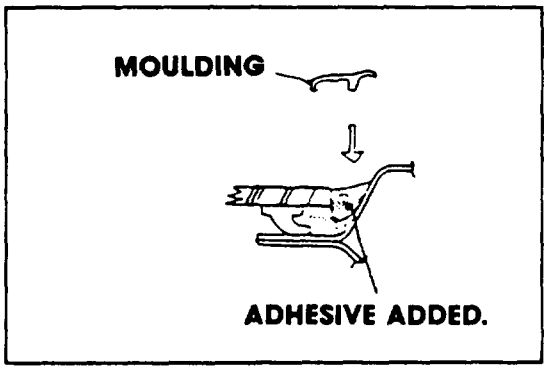

Figure 12